

Date: Thursday, 26/06/2008 11:23:26 AM
 User: Melanie Fauteux

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 40121
 Estimate Number : 10804
 P.O. Number :
 This Issue : 26/06/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type :
 Previous Run : 00015
 Written By :
 Checked & Approved By : MF 08-06-26
 Comment :

Drawing Name : DSI 9332
 Part Number : Z_CUSTOM
 Drawing Number : DSI 9332
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 26/07/2008

Qty: 2

Additional Product

Job Number:

DART			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-628-022BL	CHG	CHG002
DESC.	Heli-Access-Step RH	STC	SH98-14
LOT	B35184	STC	SA00500SE
MODEL	Bell 206L/L1/L3/L4	STC	
MADE IN CANADA			

TEL: 1-613-632-3336
 FAX: 1-613-632-4443

CHG002	CHG	STC	STC	STC
SH98-14	STC	STC	STC	STC
SA00500SE	STC	STC	STC	STC
D206-628-021BL	P/N	DESC.	LOT	MODEL
Heli-Access-Step LH				
B35183				
206L/L1/L3/L4				

MADE IN CANADA

Seq. #: Machine Or Operation:

1.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

PULL FROM STOCK: D206-628-021 B# 35183 CHG 002
 D206-628-022 B# 35184 CHG 002

Tools:

2.0

PACKAGING 2

PACKAGING RESOURCE #2

Comment: PACKAGING RESOURCE #2

ADD PAPERWORK FOR DSI 9332
 REMOVE OLD CHG # 2 LABELS
 REPLACE WITH NEW LABELS AT CHG #3 WITH ORIGINAL BATCH NUMBER

3.0

D2732030

Rubber Cushion

Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)
 Rubber Cushion

4.0

AN414A

Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)
 Bolt

5.0

AN415A

Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)
 Bolt

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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: DSI 9332

Job Number: 40121

Part Number: Z_CUSTOM

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

INSURE PAPERWORK FOR DSI 9332 IS INSTALLED
VERIFY NEW ARE LABELS ARE INSTALLED

S 08/06/08 (x2)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

**ENGINEERING
APPROVAL**

UP 08.06.26 (x2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/26 fj

Job Completion



MF 08-06-26

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. E

REF FAA STC: SA00500SE

REF CANADIAN STC: SH98-14

To help prevent the D206-628-XXX Heli-Access-Steps from sliding down the crosstubes during operation, D2732-030 Rubber Cushions have replaced the D2856-400-625/-690 Abrasion Strips in the kits shown in Table 1. The parts lists are amended as shown in Tables 2a and 2b or 3a and 3b. Install the D2732-030 Rubber Cushions as shown in Figure 1.

For customers who would like to upgrade their D206-628-011/-012/-013/-014/-021/-022/-023/-024/-031/-032/-033/-034 Heli-Access-Steps to have the D2732-030 Rubber Cushions, DSI 9332-011/-021 kits available as shown in Table 4. Remove the abrasion strips as described on Sheet 3 and install the DSI 9332-011/-021 kits as shown in Figure 1.

Table 1: D206-628-XXX Kits with D2732-030 Rubber Cushion

INSTALLATION	CHG NUMBER
D206-628-011/-012/-021/-022/-023/-024/-031/-032/-033/-034	003 OR LATER
D206-628-013/-014	004 OR LATER

Table 2a: Parts to Remove

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	PART NUMBER	DESCRIPTION
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1	1			2	2	D2856-400-625	ABRASION STRIP
1	1	2	2			D2856-400-690	ABRASION STRIP
4	4			4	4	AN4-11A	BOLT
4	4	4	4	4	4	AN4-12A	BOLT
		4	4			AN4-13A	BOLT

Table 2b: Parts to Add

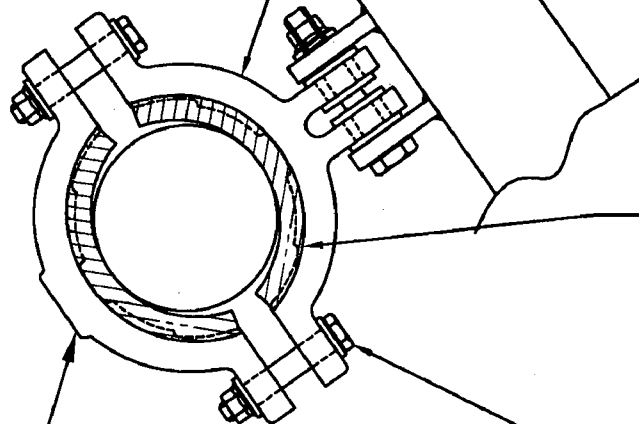
Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	PART NUMBER	DESCRIPTION
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
		4	4			AN4-15A	BOLT

Wb 40121

B	ADD DSI 9403-011/-021 KITS	PH	08.01.24
A	NEW ISSUE	MB	06.05.10
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>PH</i>		
CHECKED	<i>LE</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9332	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RUBBER CUSHION ADDITION	NTS
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D3394-041 LUG (1) OR
D3394-043 LUG (1)
(4 PLACES - REFER
TO TABLE 5)

*ACCEPTABLE TO USE LONGER/SHORTER
AN4 BOLTS AS REQUIRED AND/OR INSTALL
EXTRA AN960JD416 WASHERS UNDER THE BOLT HEADS
TO ENSURE 1.5 TO 4 THREADS IN SAFETY



D2732-030 RUBBER CUSHION
(8 PLACES)

D2731-3 LUG (1) OR
D2731-7 LUG (1)
(4 PLACES - REFER TO TABLE 5)

INSTALL LONGER AN4 BOLTS PER TABLE 5
AND FIGURE 2 OR 4 OF IIN-D206-628 REV E
AS APPLICABLE

FIGURE 1: DSI 9332-011 RUBBER CUSHION INSTALLATION (REGULAR STEPS)
(DSI 9332-021 KIT (FLOAT STEPS), SIMILAR)

Table 5: Bolts/Lugs for Installation

Aircraft	Location	Lugs	Bolts to Use for Regular Steps	Bolts to Use for Float Compatible Steps
206 B Series	Aft X-tube	D3394-041/ D2731-3	AN4-13A	AN4C13A
	Fwd X-tube	D3394-043/ D2731-7	AN4-14A	AN4C14A
206 L Series	Aft X-tube	D3394-043/ D2731-7	AN4-15A	AN4C15A
	Fwd X-tube	D3394-043/ D2731-7	AN4-14A	AN4C14A
407 Series	Aft X-tube	D3394-041/ D2731-3	AN4-13A	AN4C14A
	Fwd X-tube	D3394-041/ D2731-3	AN4-14A	AN4C14A

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Table 3a: Parts to Remove

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	PART NUMBER	DESCRIPTION
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
1	1			2	2	D2856-400-625	ABRASION STRIP
1	1	2	2			D2856-400-690	ABRASION STRIP
4	4					AN4C11A	BOLT
4	4	4	4	8	8	AN4C12A	BOLT
		4	4			AN4C13A	BOLT

Table 3b: Parts to Add

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	PART NUMBER	DESCRIPTION
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
		4	4			AN4C15A	BOLT

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Table 4: Upgrade Kits

QTY -011	QTY -021	PART NUMBER	DESCRIPTION
X		DSI 9332-011	RUBBER CUSHION KIT (D206-628-011/-012 206 A/B STEPS) (D206-628-021/-022 206L STEPS) (D206-628-031/-032 407 STEPS)
	X	DSI 9332-021	RUBBER CUSHION KIT (D206-628-013/-014 206 A/B FLOAT STEPS) (D206-628-023/-024 206L FLOAT STEPS) (D206-628-033/-034 407 FLOAT STEPS)
8	8	D2732-030	RUBBER CUSHION
4		AN4-13A	BOLT
4		AN4-14A	BOLT
4		AN4-15A	BOLT
16		AN960JD416	WASHER
8		MS21042L4	NUT (OR MS21042-4)
	4	AN4C13A	BOLT
	8	AN4C14A	BOLT
	4	AN4C15A	BOLT
	16	AN960C416	WASHER
	16	NAS1515H4L	WASHER
	8	MS21043-4	NUT

Note: Some AN4 bolts will not be used for all installations

ABRASION STRIP REMOVAL

1. Being careful not to mark/scratch the part on which it is installed, lift edge and carefully peel Abrasion Strip at an angle of 90 to 180 degrees. Speed and angle of removal may affect amount of residue and the amount of paint removed.
2. Remove adhesive with 3M 8908 Woodgrain and Stripe Remover (or equivalent). Scrape softened adhesive off the surface using plastic squeegee after the remover has sat for the required amount of time. Repeat if required.
3. Remove remaining adhesive by scrubbing area with a cloth and 3M 8908 Woodgrain and Stripe Remover (or equivalent). Scotchbrite may be used as required.
4. Saturate a clean cotton cloth with Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser followed by alcohol, or equivalent and wipe the surface to clean the entire area.

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